

Date: Thursday, 29/05/2008 8:39:07 AM  
User: Julie Lecocq

## **Process Sheet**

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: STRUT		
Job Number	: 39545						
Estimate Number	: 10951						
P.O. Number	:			Part Number	: D2562003		
This Issue	: 29/05/2008 S.O. No. :			Drawing Number	: D2562 REV D		
Prsht Rev.	: NC			Project Number	: N/A		
First Issue	: / / Type : SMALL /MED FAB			Drawing Revision	: D		
Previous Run	: 31968			Material	:		
Written By	:			Due Date	: 30/05/2008 Qty: 10 Um: Each		
Checked & Approved By	: JUO 08.5.29						
Comment	: Est D 02.04.15 Added dwg Rev.B1 and finish NG						
<b>Additional Product</b>							
Job Number:							
<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>					
1.0	M304TR0500W035	304 RD Tube .500 x .035W 					
<b>Comment:</b> Qty.: 1.9250 f(s)/Unit Total: 19.2497 f(s) 304/316/318-2B Seamless Tubing, 1/2" O.D. x 0.035" wall Batch M108215							23 08/06/04
2.0	BRAKE NC	NC BRAKE 					
<b>Comment:</b> NC BRAKE Punch to length as per Dwg D2562							SA 08/06/04
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 					
<b>Comment:</b> SMALL/MED FAB RESOURCE 1- Bend end as per Dwg D2562 Angle "D" 2- Deburr							E 08/06/04 (10) → 08/06/04 AM (10)
4.0	QC5	INSPECT WORK TO CURRENT STEP 					
<b>Comment:</b> INSPECT WORK TO CURRENT STEP							S 08/06/10 (X10)
5.0	POWDER COATING	POWDER COATING 					
<b>Comment:</b> POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3							(10X)
START TIME:	3:40 pm						
OVEN TEMPERATURE:	400 °F						
FINISH TIME:	4:10 pm						
							M-1 08/06/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 39545

Part Number: D2562003

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



(B)

Comment: INSPECT POWDER COAT

Fd 08/06/11

7.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST264

R 08/11 10

8.0 QC21 FINAL INSPECTION/W/O RELEASE



08/06/12 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



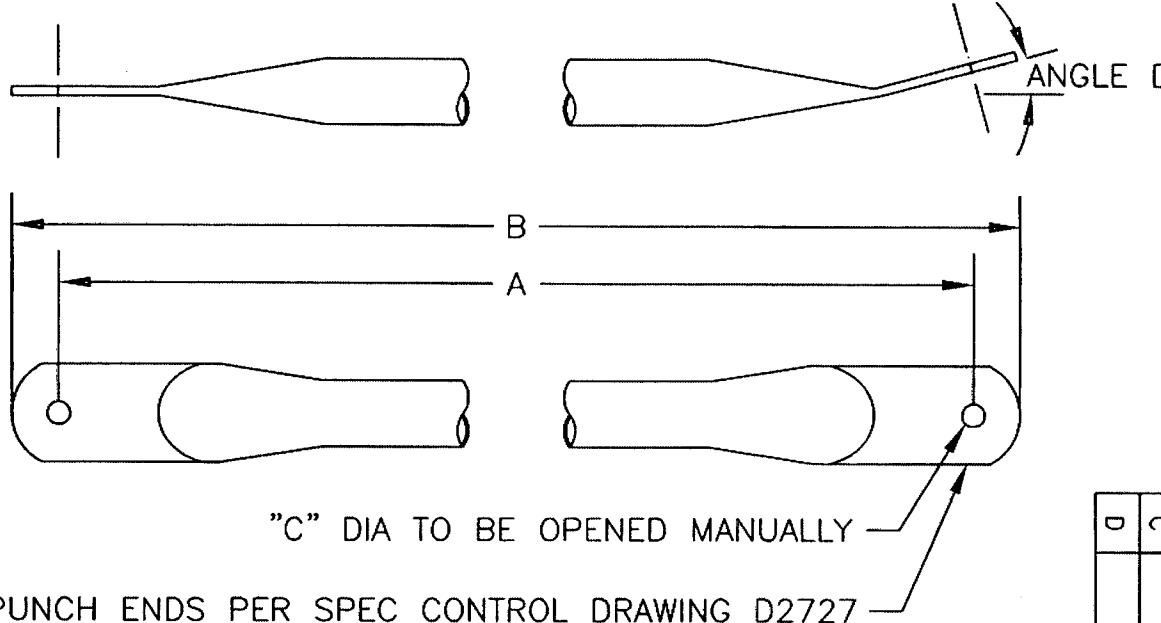
MF 08-06-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



PUNCH ENDS PER SPEC CONTROL DRAWING D2727

PART #	DIM A	DIM B	DIA C	ANG D
D2562-001	19.68	20.48	-	10
D2562-003	20.37	21.17	-	18
D2562-005	29.00	29.80	-	30
D2562-007	19.22	20.02	-	0
D2562-011	25.79	26.59	-	16
D2562-013	26.63	27.43	-	24

## **GENERAL NOTES**

- 1) MATERIAL: AISI 304/316/318 SS 0.500 OD X 0.035 WALL (REF DART SPEC. M304TR0.500W.035)  
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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05-27-09

**DART**

PARTY

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